

Work Order ID 53180

October 26, 2009 10:11:54 AM

Page 1

Item ID: D2525-5

Accept

Revision ID: B

Item Name: Spacer

Start Date: 26/10/2009 Start Qty: 10.00

Required Date: 03/11/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *PL*Date: *09-10-26*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2525

Rev B

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-Turn Blank as per Dwg D2525-2-Deburr

0.00

0.00

*SA 09/10/29**10* *0*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*SA 09/10/29**10* *0*

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

mm
*09/10/29**10* *0*

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Item ID: D2525-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacer

Start Date: 26/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

OK 09-10-29

(10)



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

OK 09/10/29

(X10)



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/29 (10x) SL

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Item ID: D2525-5

Accept



Setup Start



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Stop



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Start Date: 26/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02

MF 09-10-30

Picklist Print

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Work Order ID: 53180



Parent Item: D2525-5RevB



Parent Item Name: Spacer

Start Date: 26/10/2009

Required Date: 03/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	99.6753	0.2189			
6061-T6 Round Bar .750"												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	99.6753	
110791	2.97	
112041	8.4053	
112442	50	
112663	38.3	

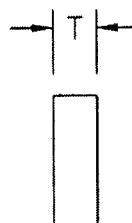
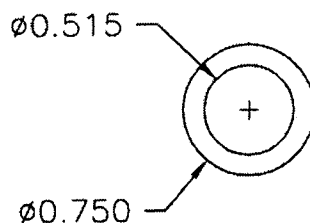
26/10/30



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 Ke

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53180

BT 09-10-26

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1